### Work Order ID 58298

May 3, 2010 10:35:01 AM

**Required Date: 13/05/2010** 



Page 1

Item ID:

DSI 9494-011

Accept

Accept

Oty

Setup Start

Stop



Revision ID:

Start Date:

Item Name:

212/412 Canister Upgrade

03/05/2010

Start Oty: 4.00 v Req'd Qty: 4.00

**Cust Item ID:** 

**Customer:** 

Reference:

Approvals:

QC:

Process Plan:

Date:

Date: //>5-18 Tooling:

Date:

Date:

Run

Start

Stop

Sequence ID/ **Work Center ID** 

Draw Nhr

Operation Description

**Revision Nbr** 

Set Up/ Run Hours

SPC (Y/N):

Draw Number Draw Plan Rev. Code Reject Otv

Reject Insp. Number Stamp

DSI 9494 Α

100

Document Control

Memo

CHG001

Photocopy bluefile &type labels per PPP DSI 9494-011

0.00

110

Packaging Packaging

Pick Kit

0.00

Memo

Memo

0.00

120

Quality Control

QC4- 100% Inspect kits for completeness

0.00

0.00

Sidesti

# Dart Aerospace Ltd W/O: WORK ORDER CHANGES DATE STEP PROCEDURE CHANGE By Date Qty Chief Eng / Prod Mgr

		MO	DI ODDED HON CONFORM	ANOF (NOD)		
	Resolution:		Disposition:	QA: N/C Closed:	Date:	
Part No:		_PAR #:	Fault Category:	NCR: Yes No DQA:	Date:	

Approvál QC Inspector

NCR:			WORK ORDE	ER NON-CONFORMAN	CE (NCR)			
DATE		Description of NC		Corrective Action Section B	}	Verification	A	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector
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		:			:			
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### Work Order ID 58298

May 3, 2010 10:35:01 AM



Page 2

Item ID:

DSI 9494-011

Accept



Setup Start

Stop



**Revision ID:** 

Item Name:

212/412 Canister Upgrade

Start Date:

03/05/2010

Start Otv: 4.00

Reg'd Oty: 4.00 **Required Date: 13/05/2010** 

Operation

Description



**Cust Item ID: Customer:** 

Reference:

А	n	n	ro	V	al	S	:

Process Plan:

Tooling: Date:

SPC (Y/N):

Set Up/

Run Hours

Draw

Number

Date:

Draw

Rev.

Plan

Code

Date:

Run Start

Reject

Qty

Accept

Qty



Stop



Number | Stamp

Reject

Sequence ID/

Work Center ID

130

Packaging Packaging

Memo

0.00

0.00

Identify and pack for shipping as per PPP DSI 9494-011

Date: \_\_\_\_

Location: PPP rev:

140

QC21- Final Inspection - Work Order Release

0.00

OC

Quality Control

Memo

0.00

- 1005. MF 10-5-17

### **Dart Aerospace Ltd**

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W/O:		į									
DATE	STEP		PR	OCEDURE CHAN	IGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approvál QC Inspector
		I									
Part No	•		PAR #:	Fault Categ	ory:	NCF	R: Yes	No <b>DQ</b> /	A:	 Date:	
	Re	esolution:		Disposition	:	QA:	N/C CI	osed:		Date:	
NCR:			1	WORK ORDE	R NON-CONFORM	IANCE	(NCR	)			
DATE	STEP	De	scription of NC			ction B		Verific	ation	Approval	Approval
	J.L.	· · · · · · · · · · · · · · · · · · ·	Section A	Initial Chief Eng	Action Description Chief Eng			Sign & Secti		Chief Eng	QC Inspector
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### **Picklist Print**

May 3, 2010 10:35:07 AM

Work Order ID: 58298

Parent Item:

DSI 9494-011

Parent Item Name:

212/412 Canister Upgrade

Comments:

NUT

IPP Rev:A new issue DD 10.03.31 verified by:EC

Purchased

Purchased

No



Start Date: 03/05/2010

**Required Date: 13/05/2010** 

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
AN815-8D		Purchased	No			110	Each	23.0000				
										,	. /	
Union-M-Flare												/

AN833-8D	
ELBOW	

	<b>Location</b>	<u>Lo</u>	c Oty	Loc Code
	ST329		. 23	
	108672		3	
	113749		10	
	114544		.10	,
No		110	Each	24.0000

Location		Loc	e Qty	Loc Code
ST333			24	
1	0		10	
1	13706		4	
1	14544		10	
		110	Each	24.0000

oc Qty	Loc Code	
24		
10		
4		M1/3706
10		
Each	24.0000	

Location	Loc Oty	Loc Code
ST335	20	
114341	10	
114544	10	
ST336	4	
113706	4	

\_\_\_\_\_

M108672

1/3706

₩/O:			WC	RK ORDER CHAN	NGES						
DATE	STEP	. PI	ROCEDURE CHAI	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approv QC Inspect	
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		1									
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Part No	):	PAR #:	Fault Cate	gory:	NC	R: Yes	No <b>DQ</b>	A:	Date:	<u> </u>	
					QA: N/C Closed:						
	Hes	solution:	Disposition	າ:							
NCR:	Hes	solution:		ER NON-CONFOR	QA	: N/C CI	osed:				
			WORK ORDE	ER NON-CONFOR	QA	: N/C CI	osed: R)		Date:		
NCR:	STEP	Description of NC Section A	WORK ORDE	ER NON-CONFOR	MANCE Section B	: N/C CI	osed: l) Verifi				
		Description of NC	WORK ORDE	ER NON-CONFOR  Corrective Action S  Action Description	MANCE Section B	: N/C CI E (NCF	osed: l) Verifi	cation	Date:	Approva	
		Description of NC	WORK ORDE	ER NON-CONFOR  Corrective Action S  Action Description	MANCE Section B	: N/C CI E (NCF	osed: l) Verifi	cation	Date:	Approva	
		Description of NC	WORK ORDE	ER NON-CONFOR  Corrective Action S  Action Description	MANCE Section B	: N/C CI E (NCF	osed: l) Verifi	cation	Date:	Approva	
		Description of NC	WORK ORDE	ER NON-CONFOR  Corrective Action S  Action Description	MANCE Section B	: N/C CI E (NCF	osed: l)  Verifi	cation	Date:	Approva	
		Description of NC	WORK ORDE	ER NON-CONFOR  Corrective Action S  Action Description	MANCE Section B	: N/C CI E (NCF	osed: l)  Verifi	cation	Date:	Approva	

### **Picklist Print**

May 3, 2010 10:35:07 AM

Page 2/3

Work Order ID: 58298

Parent Item:

DSI 9494-011

Parent Item Name:

212/412 Canister Upgrade

Comments:

IPP Rev:A new issue DD 10.03.31 verified by:EC



**Start Date:** 03/05/2010

**Required Date: 13/05/2010** 

Start Otv: 4.00

Required Qty: 4.00

Comments:	IPP Rev:A new iss	sue DD 10.03.31	verifie	d by:EC				5	Start Qty: 4.00		Required Qty:	4.00
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
D3262:043	18 JULI 11 11 11 11 11 11 11 11 11 11 11 11 11	Manufactured	No			110	Each .	1.0000		35	8298/	0.5-11
				Location	<u>l</u>	Loc	<u>Oty</u>	Loc Code				
				ST144			1					
2000					57408		1		egy years			
3299-7	101)   101)	Manufactured	No			110	Each	20.0000	1x. y 🗸	ئے۔		
itting		: :										
uing				Location	•	Loc	06:	Loc Code				
				ST050	<u>-</u>	Loc	20	Loc Code				
				51050	57411		20			741		
1054-001		Manufactured	No			110	Each	6.0000		~		
ıbe Assembly	<b>i</b> rii <b>11</b> 11 ii 111 ii 111										/,	D-7
		i		Location	1	Loc	Qty	Loc Code				
		Ĭ		ST193			6					
		1			57412		6		a come	574/2	<b>~</b>	
4054-003		Manufactured	No			110	Each	6.0000				7
ube Assembly												140/11
				Location	1	Loc	Qty	Loc Code				
. f				ST193			6					
!					57413		6			57413		

## Dart Aerospace Ltd

W/O:		i.		WC	RK ORDER CHANG	GES			1		·
DATE	STEP	!	PR	OCEDURE CHA	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No					gory:						
	R	esolution:		Disposition	າ:	QA:	N/C Clo	sed:		Date: _	
NCR:		l		WORK ORD	ER NON-CONFORM	ANCE	(NCR				
DATE	STEP	Desc	cription of NC			ction B		Verific	ation	Approval	Approval
	J.L.	1	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Section		Chief Eng	QC Inspector
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### **Picklist Print**

May 3,:2010 10:35:07 AM

Page 3/3

Work Order ID: 58298

Parent Item:

DSI 9494-011

Parent Item Name: 212/412 Canister Upgrade

Comments:

IPP Rev:A new issue DD 10.03.31 verified by:EC

Purchased



Start Date: 03/05/2010

Required Date: 13/05/2010

Start Qty: 4:00

Required Oty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
D4054-009 Tube Assembly		Manufactured	No			110	Each	6.0000	; 1 	57414		

MS29512-08	e	

Location ST110

No

110

Loc Qty Each

38.0000

Loc Code



Location Loc Qty Loc Code ST294 38 113691 3 113706 35

Dart A	eros	pace	Ltd
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W/O:			V	ORK ORDER CHANG	iES		· · · · · · · · · · · · · · · · · · ·		<b>F</b>
DATE	STEP	j	PROCEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		'		*//************************************			i		
Part No	•	PAR #:	Fault Cat	egory:	NCR: Yes	No <b>DQ</b>	A:	Date:	
				on:					
NCR:			WORK ORI	DER NON-CONFORMA	ANCE (NC	R)			
DATE	STEP	Description of NC			ion B	Verific	ation	Approval	Approval
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# **DART SERVICE INSTRUCTION**

TO AMEND INSTALLATION INSTRUCTIONS IIN-D412-706 REV. A AND ICA-D412-706 REV. 0
REF. TCCA STC: SH04-54
REF. FAA STC: SR02055NY

REF. EASA STC: EASA.IM.R.S.01180

**DESCRIPTION:** 

AT CHG 002, THE D412-706-011 FUEL PURGE CANISTER INSTALLATION HAS BEEN MODIFIED WITH LARGER VENT LINES TO ELIMINATE BACK PRESSURE THAT MAY OCCUR WHEN STARTING THE SECOND ENGINE IF THE CANISTER HAS NOT BEEN PROPERLY DRAINED. THE BACK PRESSURE IS EVIDENCED BY AN ONGOING VAPOR DISCHARGE FROM THE CANISTER VENT AT LOW TO MEDIUM RPM WHILE STARTING THE 2nd ENGINE. THE UPDATED PARTS LIST IS SHOWN BELOW:

IS

QTY -011	PART NUMBER	DESCRIPTION
<b>X</b>	D412-706-011	FUEL-PURGE CANISTER INSTALLATION (212/412)
1	D2001-4	VALVE ASSEMBLY
1	D3262-043	CANISTER ASSEMBLY (WAS D3262-041)
2	D3264-1	BRACKET
1	D3297-1-0098	HOSE ASSEMBLY
1	D3297-3-0085	HOSE ASSEMBLY
1	D3297-3-0210	HOSE ASSEMBLY
1	D4054-001	TUBE ASSEMBLY (WAS D3298-001)
1	D4054-003	TUBE ASSEMBLY (WAS D3298-003)
1	D3298-005	TUBE ASSEMBLY
1	D3298-007	TUBE ASSEMBLY
1	D4054-009	TUBE ASSEMBLY (WAS D3298-009)
1	D3299-7	FITTING (WAS 3299-1)
1	D3299-3	FITTING
1	D3299-5	FITTING
1	D3301-1	PLACARD
1	D3301-3	PLACARD
1	D3302-1	DOUBLER
1	D3302-3	DOUBLER
2	D3329-1	BUSHING
4	AN3-5A	BOLT
1	AN814-6D	PLUG
2	AN815-6D	UNION
1	AN815-8D	UNION (WAS AN815-6D)
1	AN832-6D	UNION
1	AN833-6D	ELBOW
1	AN833-8D	ELBOW (WAS AN833-6D)

**SHOP COPY** RETURN TO ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER

CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION **BRANCH** DAO # 01-O-01

APPROVED

D. SHEPHERD (DE # 02)

CERT. NO.: ISSUE NO .:

10.01.07 SH04-54

Α	NEW ISS	UE		RF	10.01.07
REV.			DESCRIPTION	BY	DATE
DESIG	N	RF	DART AEROSPA	ACE L	TD
DRAW	N	RF,	HAWKESBURY, ONTARI		
CHECK	ŒD	-#	DRAWING NO.		REV. A
MFG. A	PPR.	NA	│DSI 9494		SHEET 1 OF 3
APPRO	VED	111	TITLE		SCALE
DE APP	PR.	#	212/412 CANISTER UPG	RADE	KIT NTS
DATE	10.01	1.07	COPYRIGHT © 2010 BY DART A THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATION.	ON THE EXPRES	S CONDITION THAT IT IS

<b>Dart Aerospace</b>	Ltd
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W/O:				W	ORK ORDER CHANG	ES					
DATE	STEP		PRO	OCEDURE CH	ANGE	By	,	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	•		PAR #:	Fault Cat	egory:	NCR: Y	es N	o DQA	\:	Date:	
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NCR:				WORK ORE	DER NON-CONFORM	ANCE (N	CR)				
DATE	STEP	Des	cription of NC	1.41.1		ion B		Verific	ation	Approval	Approval
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### Continue from previous sheet

4	AN924-6D	NUT
1	AN924-8D	NUT (WAS AN924-6D)
1	AN938-6D	TEE
4	AN960JD10L	WASHER (OR NAS1149D0332J)
8	AN960JD10	WASHER (OR NAS1149D0363J)
2	AN960JD916	WASHER
4	MS21042L3	NUT
2	MS21919WDG9	CLAMP
2	MS21920-42	CLAMP
8	MS29512-06	O-RING (WAS MS28778-6)
2	MS29512-08	O-RING (WAS MS28778-6)
1	MS35489-11	GROMMET

FOR CUSTOMERS WHO HAVE EXPERIENCED THIS PROBLEM IN SERVICE, THE DSI 9494-011 UPGRADE KIT IS AVAILABLE TO UPGRADE THE INSTALLATION FROM CHG 001 TO CHG 002.

QTY -011	PART NUMBER	DESCRIPTION
Х	DSI 9494-011	212/412 CANISTER UPGRADE KIT
1	D3262-043	CANISTER ASSEMBLY
1	D4054-001	TUBE ASSEMBLY
1	D4054-003	TUBE ASSEMBLY
1	D4054-009	TUBE ASSEMBLY
1	D3299-7	FITTING
1	AN815-8D	UNION
1	AN833-8D	ELBOW
1	AN924-8D	NUT
2	MS29512-08	O-RING

### WEIGHT AND BALANCE: NO CHANGE

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CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

BY: MS D. SHEPHERD (DE # 02)

DATE: CERT. NO.: ISSUE NO.:

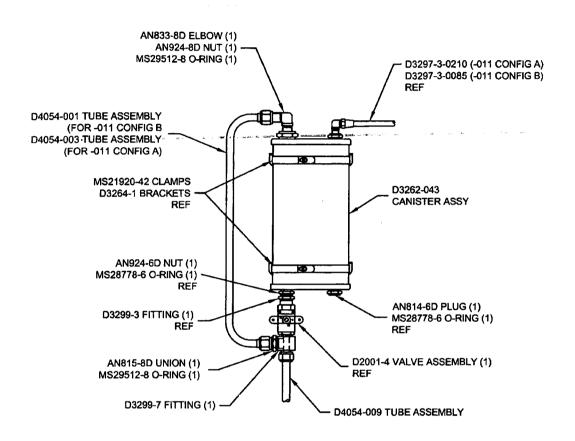
10.01.07 SH04-54 1

DESIGN	RF	DART AEROSPACE LTD				
DRAWN	RF,	HAWKESBURY, ONTARIO, CANADA				
CHECKED	#	DRAWING NO. REV. A				
MFG. APPR.	MA	DSI 9494 SHEET 2 OF 3				
APPROVED	#	TITLE SCALE				
DE APPR.	##	212/412 CANISTER UPGRADE KIT NTS				
DATE 10.0	1.07	COPYRIGHT © 2010 BY DART AEROSPACE LTD  THIS DOCUMENT IS PRIVATE AND CONFERTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS  NOT TO BE USED FOR ANY PURPOSE OR COMMINICATED TO ANY OTHER PERSON WITHOUT  WRITTEN PERMISSION FROM DART AEROSPACE LTD.				

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W/O:				W	ORK OR	DER CHAN	GES		.9.4.			
DATE	STEP		PR	OCEDURE CH	ANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:		PAR #:	Fault Cate	egory:		NCI	R: Yes	No <b>DQ</b>	<b>\:</b>	_ Date: _	
			Disposition: QA: N/C Closed:						Date:			
NCR:	-			WORK ORD	DER NON-	CONFORM	ANCE	(NCR	)		y	
DATE	STEP	Description of NC		Corrective Action Section B				Verifi		cation Appro	Approval	Approval
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# FIGURE 1. CANISTER ASSEMBLY (-011 INSTALLATION AT CHG 002)

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO#01-0-01

BY: D. SHEPHERD (DE # 02)

DATE: CERT. NO.: ISSUE NO.:

10.01.07 SH04-54 1

DESIGN	RF	DART AEROSPACE LTD					
DRAWN	RF,	HAWKESBURY, ONTARIO, CANADA					
CHECKED	#		EV. A				
MFG. APPR.	NA	DSI 9494 SHEET	3 OF 3				
APPROVED	-#	TITLE	CALE				
DE APPR.		212/412 CANISTER UPGRADE KIT					
DATE 10.0	1.07	COPYRIGHT © 2010 BY DART AEROSPACE LTD  THIS DOCUMENT IS PRIVATE AND COMPOENTIAL AND IS SUPPLED ON THE EXPRESS CONDITION TH  NOT TO BE USED FOR AN PURPOSE OF COPIED OR COMMANIACATED TO ANY OTHER PERSON WIT					

# Dart Aerospace Ltd W/O: WORK ORDER CHANGES DATE STEP PROCEDURE CHANGE By Date Other Change Of Prod Mgr Occurrence Of Prod Mgr Occurrence Occu

Part No:	PAR #:	Fault Category:		NCR: Yes No	DQA:	_ Date	e:
Resolution: _		Disposition:	(	QA: N/C Closed	•	Date	e:

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
		Description of NC		Corrective Action Section B		\	Approval Chief Eng	<b>A</b>
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C		Approval QC Inspector
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### Continue from previous sheet

4	AN924-6D	NUT
4	-AN924-8D	NUT (WAS AN924-6D)
1	AN938-6D	TEE
4	AN960JD10L	WASHER (OR NAS1149D0332J)
8	.4N980JD10	WASHER (OR NAS1149D0363J)
2	4M980JD916	WASHER '
$\mathcal{L}_{t}^{t}$	WS21042L3	NUT
2	MS21919V/DG9	CLAMP
2	MS:21920-42	CLAMP
ි ව	MS29512-05	O-RING (WAS MS28778-6)
2	N1S29512-08	O-RING (WAS MS28778-6)
1	V:\$35489-11	GROMMET

FOR CUSTOMERS WHO HAVE EXPERIENCED THIS PROBLEM IN SERVICE, THE DSI 9494-011 UPGRADE KIT IS AVAILABLE TO UPGRADE THE INSTALLATION FROM CHG 001 TO CHG 002.

QTY -011	PART NUMBER	DESCRIPTION
Ж	D319494-011	212/412 CANISTER UPGRADE KIT
	D3262-043	CANISTER ASSEMBLY
1	O4084-001 ₹	TUBE ASSEMBLY
1	L4064-003 V	TUBE ASSEMBLY
1	04054-009 3	TUBE ASSEMBLY
/	D3299-7	FITTING
1	At1815-8D 7	UNION
1	Afters3-8D (	ELBOW
1	4.4034-8D ~	NUT
2	MS 29512-06 /	O-RING

WEIGHT AND BALANCE: NO CHANGE



CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAGGOTOLOGI
APPROVED

DESIGN DRAWN	RF RE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	-14-	DRAWING NO.	EV. A
MFG. APPR. MA		DSI 9494 SHEET	2 OF 3
APPROVED	糖	· · · · · · · · · · · · · · · · · · ·	SCALE
DE APPR.	##-	212/412 CANISTER UPGRADE KIT	NTS
DATE 10.0	1.07	COPYRIGHT @ 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS FRANTE AND COMPORT. TALL AND IS SUPPLIED ON THE EXPRESS CONGITION TO NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMPUNICATED TO ANY OTHER PERSON WE WAITTEN PERMISSION FROM JAST ASPC SPACE LTD.	

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W/O:		WORK ORDER CHANGES							5 0 4			
DATE	STEP	PROCEDURE CHANGE			B	y I	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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Part No	•	PAR #:	Fault Cate	gory:	NCR: \	es No	DQA	•	Date:	<u></u>		
				Disposition: QA								
NCR:			WORK ORD	ER NON-CONFOR	MANCE (N	ICR)						
DATE	STEP	Description of NC	Corrective Action Section			Variti			Approval	Approval		
	O I E I	Section A	Initial Chief Eng	Action Description Chief Eng		gn & Date	Section C		Chief Eng	QC Inspector		
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